



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D2894-1**Job Sheet 214672****Part No:** D2894-1**Job Qty:** 6 pcs**Part Name:** 2.75 Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/29/20**Job Tracking No:****Due Date:** 12/10/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV E IPP: B 02.11.26 Added mask hole KJ IPP Rev:C ECN 993 07-11-07 DD verified by:EC IPP D 08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER REV:C DD VERF:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	12/10/20		0.79	20.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	6 pcs	12/10/20		0.00	0.00	QC 8 - 12		OK 20/11/27 / JL 20-11-28
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		J.A 20-12-09
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		

**Container No:** S316388**Part:** D2894-1**Job No:** 214672**Serial No/Batch:** S316388**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/26/20

Dart Aerospace Ltd.
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CANADA
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130 Packaging 3-1 - Stock - B4B 6 pcs	12/10/20	0.00 0.00	QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	DAS
			Packaging 3 - 22 - B4B	41 DEC 10 2020
			Packaging 3 - 23 - B4B	3-89
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	DAS
140 QC 21 - SA 6 pcs	12/10/20	0.00 0.00	QC 21 - SA - 21	21
			QC 21 - SA - 70	9-89
			QC 21 - SA - 9	
			QC 21 - SA - 77	
			QC 21 - SA - 28	

Part Op 100 - (HAAS CNC Vertical Machine) Machine as per Folio FA253 Tumble & Deburr
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: LG051)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK079	D2894-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	5200894

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK079	3	6	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	0.454Inches	+ 0.020 - 0.000	0.474 0.454	
2	2.750 Support	3.062Inches	+ 0.020 - 0.000	3.082 3.062	
3	2.750 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053	
4	2.750 Support	1.766Inches	+ 0.020 - 0.000	1.786 1.766	
5	2.750 Support	0.020Inches	+ 0.020 - 0.000	0.040 0.020	
6	2.750 Support	0.260Inches	+ 0.007 - 0.000	0.267 0.260	
7	2.750 Support	0.170Inches	+ 0.020 - 0.000	0.190 0.170	
8	2.750 Support	0.150Inches	+ 0.020 - 0.000	0.170 0.150	
9	2.750 Support	1.970Inches	+ 0.060 - 0.000	2.030 1.970	
10	2.750 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
11	2.750 Support	1.880Inches	+ 0.020 - 0.000	1.900 1.880	
12	2.750 Support	0.500Inches	+ 0.005 - 0.000	0.505 0.500	
13	2.750 Support	0.188Inches	+ 0.006 - 0.000	0.194 0.188	

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DART AEROSPACE LTD		Work Order: 214672
Description: Ø2.750 Support		Part Number: D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.464	.464	.464	.464	.464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		.063	.063	.063	.063	.063
AD	1.766	1.786		1.176	1.177	1.174	1.176	1.177
AE	0.020	0.040		.030	.030	.030	.030	.030
AF	0.260	0.267		.260	.260	.260	.260	.261
AG	0.170	0.190		.180	.180	.180	.180	.180
AH	0.150	0.170		.160	.160	.160	.160	.160
AI	1.970	2.030		1.999	1.999	2.000	2.000	1.998
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	1.880	1.900		1.890	1.890	1.890	1.891	1.887
AL	0.500	0.505		.500	.500	.500	.500	.500
AM	0.188	0.194		.190	.190	.190	.190	.191
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				.001	.001	.0005	.0025	.0025

Measured by: GJK / SL	Date: 20/11/27
Audited by: B.A.	Date: 20-12-09
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	

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HAAS Section								
AA	0.454	0.474		0.464				
AB	3.062	3.082		3.072				
AC	0.053	0.073		0.063				
AD	1.766	1.786		1.776				
AE	0.020	0.040		0.030				
AF	0.260	0.267		0.261				
AG	0.170	0.190		0.180				
AH	0.150	0.170		0.160				
AI	1.970	2.030		1.998				
AJ	0.240	0.260		0.250				
AK	1.880	1.900		1.888				
AL	0.500	0.505		0.500				
AM	0.188	0.194		0.191				
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				0.001				

Measured by: JL	Date: 20-11-28
Audited by: B.e	Date: 20-12-09
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					